

Work Order ID 69548

Wednesday, May 11, 2011 3:16:56 PM



Page 1

Item ID: D3651-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Base

Start Date: 5/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3651	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 .018

B11-519

②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-519

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

81105119

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

SB 1165125

(2)

Brake NC

Form as per Dwg D3651

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 1165130

(2)

Quality Control

150



Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

SB 1165130

(2)

Packaging

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Page 3

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Stop



Item Name: Base

Start Date: 5/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30

11-05-30
(2)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 3:17:02 PM

Page 1

Work Order ID: 69548

Parent Item: D3651-3

Parent Item Name: Base



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA

Purchased

No

100

sf

15.0000

0.474

0.997895



B11-5-19

304/316 0.018 SHEET

Location

Loc Qty

Loc Code

MAT020

15

109398

3

112885

12

112885

2

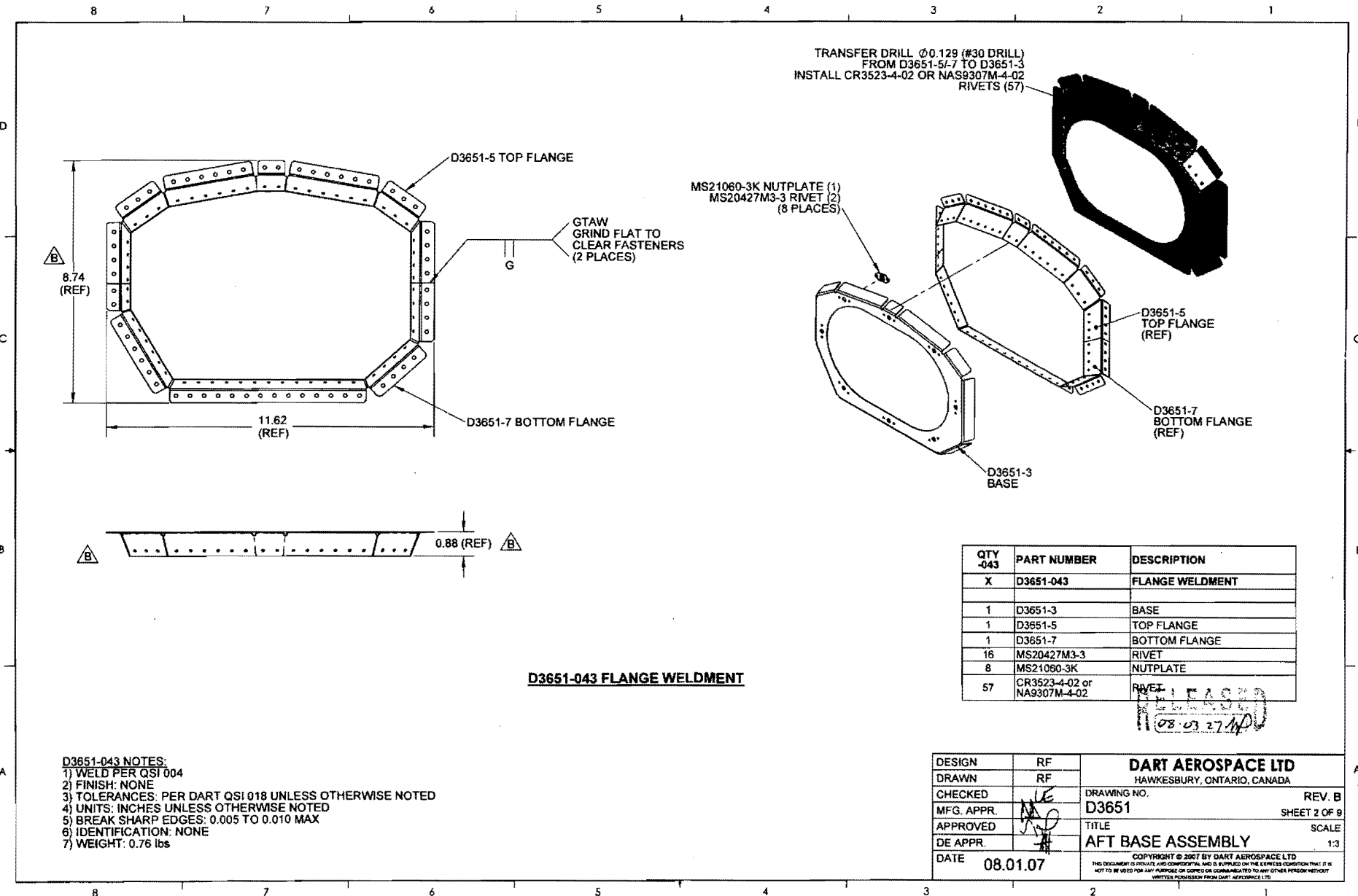
W/O:		WORK ORDER CHANGES					
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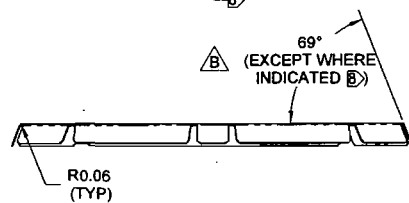
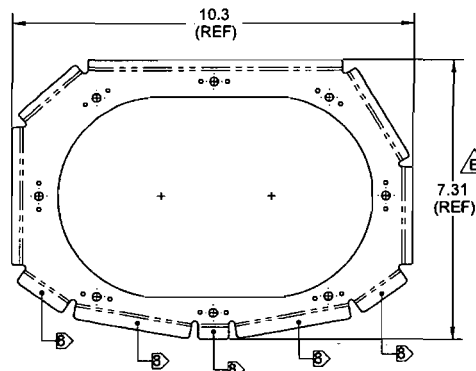
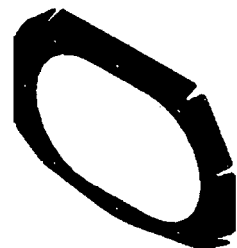
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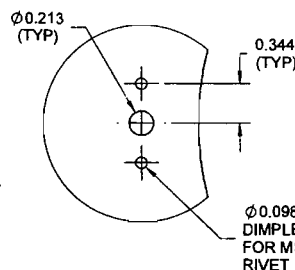
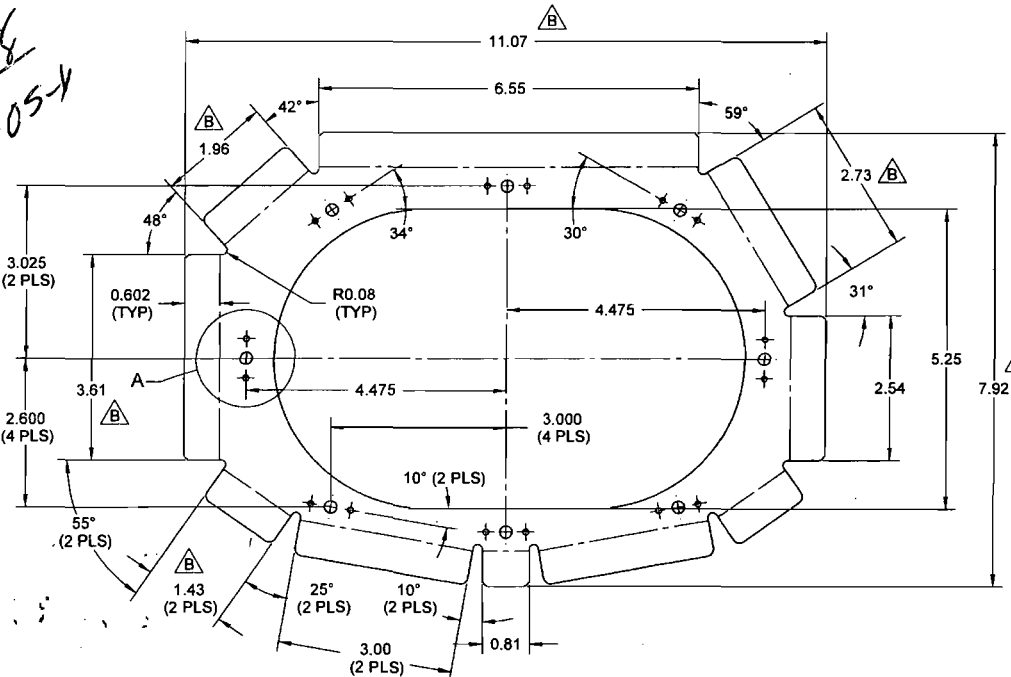
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69548
PL 11-054



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs
8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

08-03-27 MJD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D3651	REV. B
MFG. APPR.	MJD	SHEET 4 OF 9	
APPROVED	MJD	TITLE	SCALE
DE APPR.	MJD	AFT BASE ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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